

# Work Order ID 78762

January-13-12 10:47:13 AM

**\*78762\***

Page 1

Item ID: D3163-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Cover Assembly  
 Start Date: 13/01/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 27/01/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: MLG Date: 12/01/13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3163	Rev E								
100		0.00							
<b>*100*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Rivet D3163-3 to D3163-1 Ensure holes line up								
110		0.00							
<b>*110*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
<b>*120*</b>	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>2:40</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>3:10</u>								

M122966

2  $\phi$  FF 13-04-05

2

134.8

2x  $\phi$  m/f 13/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Small Fab	0.00							
<b>*140*</b>									
Small Fab	Memo	0.00							
Small Fab	Install Nut Plates as per Dwg D3163								
150	QC5- Inspect part completeness to step on W/O	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
06  
9-89

27

13-4-10

FF

2

13-04-11

31

13 4 11

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**\*78762\***

Page 3

**\*N900040100\***

Setup Start **\*NS1\***

Stop \*NS2\*

\*2\*

**Cust Item ID:**

\*2\*

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

Identify as per dwg & Stock Location:

0.00

**\*160\***

### Packaging

## Memo

0.00

## Packaging

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

## Memo

0.00

## Quality Control

2x

80  
B-4-15

13/4/16

DB-04-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January-13-12 10:47:17 AM

Page 1

Work Order ID: 78762

\*78762\*

Parent Item: D3163-042

\*D3163-042\*

Parent Item Name: Cover Assembly

Start Date: 13/01/2012

Required Date: 27/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A05.10.25New issueKJ/RF  
IPP Rev:B 06-07-03 As per Rev D JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3163-1		Manufactured	No			100	Each	4.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

\*D3163-1\*

Plate

\*\*

FF 13-04-05

Location

Loc Qty

Loc Code

ST178

4

57752

4

2

D3163-3		Manufactured	No			100	Each	3.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

\*D3163-3\*

Plate

\*\*

FF 13-04-05

Location

Loc Qty

Loc Code

ST178

3

57753

3

2

MS20426AD3-4		Purchased	No			100	Each	4,364.000	4	8			
--------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

\*MS20426AD3-4\*

RIVET

\*\*

FF 13-04-05

Location

Loc Qty

Loc Code

ST316

4364

104374

1060

110398

3304

8

MS20426AD3-5		Purchased	No			140	Each	12,686.00	4	8			
--------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

\*MS20426AD3-5\*

Rivet

\*\*

FF 13-04-11

Location

Loc Qty

Loc Code

ST316

12686

4179

872

4444

5654

4533

6160

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

January-13-12 10:47:17 AM

Page 2

Work Order ID: 78762

\*78762\*

Parent Item: D3163-042

\*D3163-042\*

Parent Item Name: Cover Assembly

Start Date: 13/01/2012

Required Date: 27/01/2012

Start Qty: 2.00

Required Qty: 2.00

MS21059L08

Purchased

No

140

Each

253.0000

2

4

\*MS21059I 08\*

\*\*

FF

13-04-11

Nut

Location

Loc Qty

Loc Code

ST300

123900

253

112314

200

12706

53

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

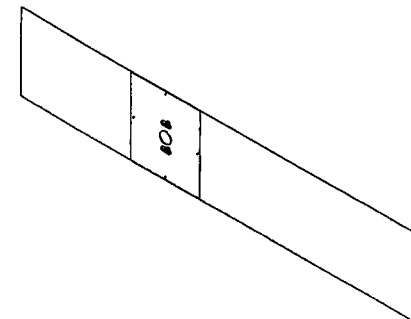
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3163-041	PLATE
2	1	D3163-1	PLATE
3	1	D3163-3	PLATE
4	4	MS20426AD3-4	RIVET
5	4	MS20426AD3-5	RIVET
6	2	MS21059L08	NUTPLATE



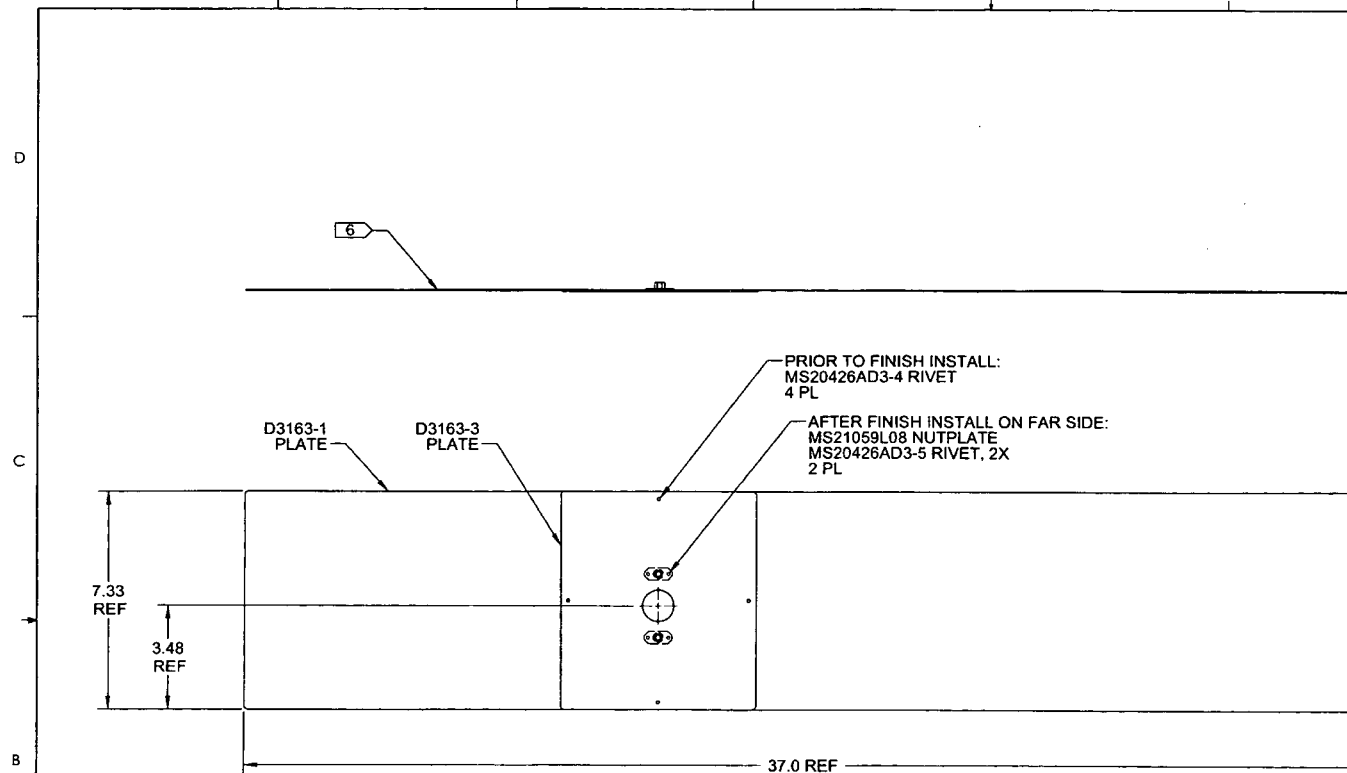
**RELEASED**  
2009-11-09  
*mp*

### D3163-041 PLATE

SHOP COPY  
RETURN TO  
ENGINEER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 78762 H.C.J.  
12/01/13

E	REDRAW, 13.69 WAS 12.81 (TYPO, ZN B6-3), NCR 09-095	CP	09.10.21
D	ADD 4 RIVETS, RMV ADHESIVE	CB	06.06.26
C	Ø1.050 WAS Ø1.000	RF	05.11.22
B	7.33 WAS 7.26, RMV PERIMETER HOLES	RF	04.10.06
A	NEW ISSUE	RF	02.04.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3163	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLATE	NTS
DATE	09.10.21	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE  
PRIOR TO INSTALLATION OF MS21059L08 NUTPLATES
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 1.00 lbs



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

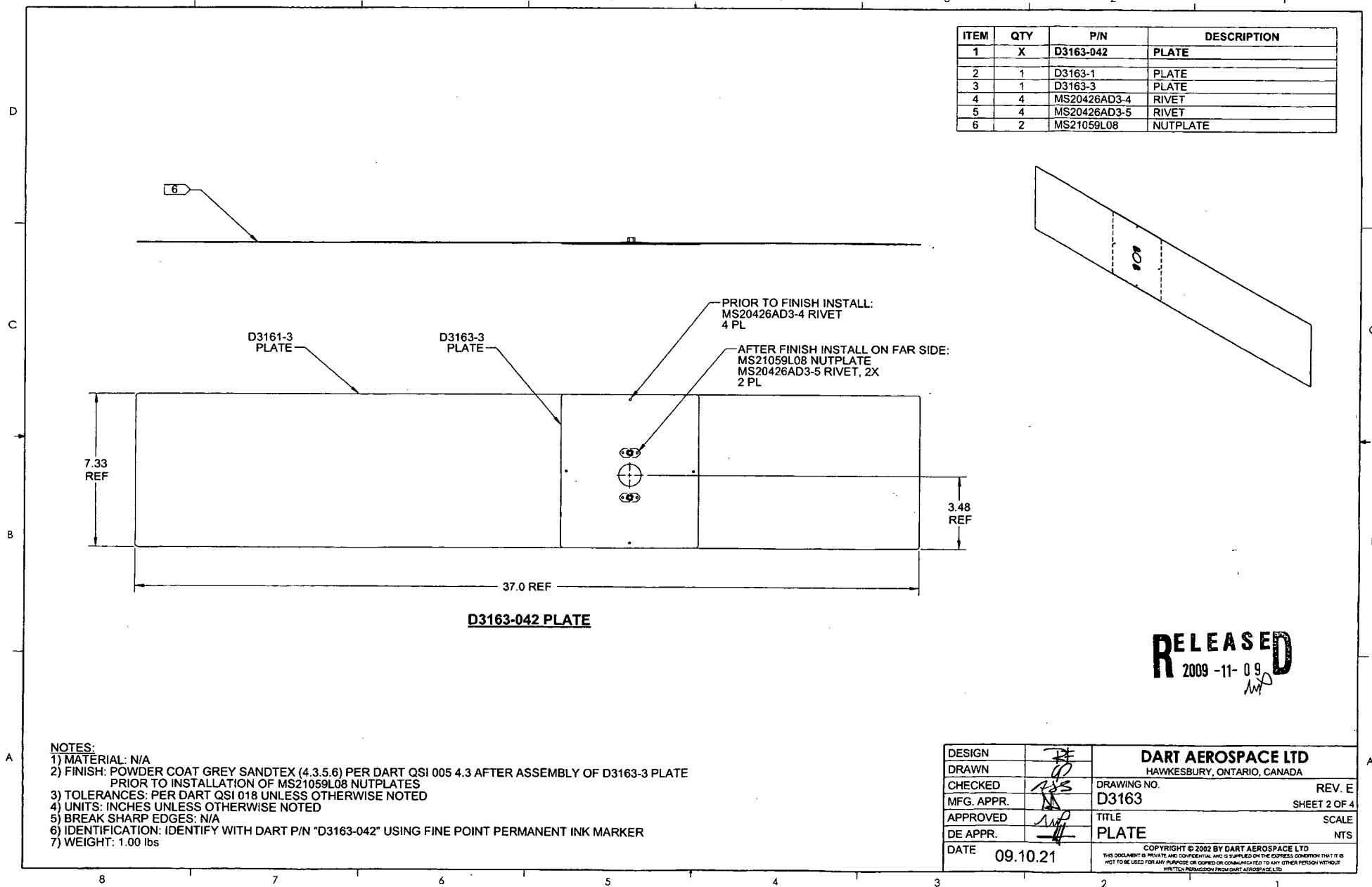
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78762

ITEM	QTY	P/N	DESCRIPTION
1	X	D3163-042	PLATE
2	1	D3163-1	PLATE
3	1	D3163-3	PLATE
4	4	MS20426AD3-4	RIVET
5	4	MS20426AD3-5	RIVET
6	2	MS21059L08	NUTPLATE



**RELEASED**  
2009-11-09  
AW

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE  
PRIOR TO INSTALLATION OF MS21059L08 NUTPLATES
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-042" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 1.00 lbs

DESIGN	FE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO. <b>D3163</b>	REV. E
MFG. APPR.	AW	SHEET 2 OF 4	
APPROVED	AW	TITLE	SCALE
DE APPR.	AW	<b>PLATE</b>	NTS
DATE	09.10.21	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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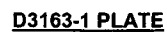
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

RELEASED  
2009-11-09  
WFO



- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/4, REF DART SPEC. M2024T3S.032  
OR 6061-T6 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/11, REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.84 lbs

DESIGN	<i>BE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3163</b>  TITLE <b>PLATE</b>  COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	REV. E
DRAWN	<i>GO</i>		SHEET 3 OF 4
CHECKED	<i>A/S</i>		SCALE
MFG. APPR.	<i>MD</i>		NTS
APPROVED	<i>MD</i>		
DE APPR.	<i>MD</i>		
DATE	09.10.21		

W/O:		WORK ORDER CHANGES					
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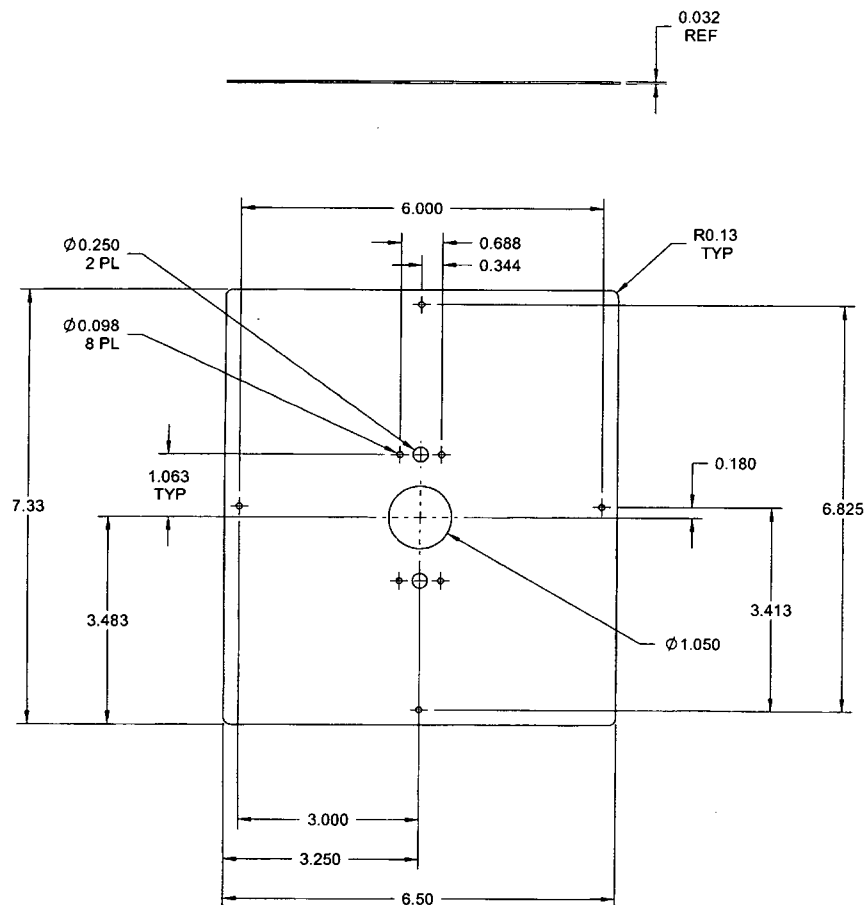
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78762



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/4, REF DART SPEC. M2024T3S.032 OR 6061-T6 ALUMINUM SHEET 0.032 THICK PER QQ-A-250/11, REF DART SPEC. M6061T6S.032
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3163-3" USING REMOVABLE TAG
- 7) WEIGHT: 0.15 lbs

RELEASED  
2009-11-09

DESIGN	<del>JS</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>JS</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>JS</del>	DRAWING NO.	REV. E
MFG. APPR.	<del>JS</del>	D3163	SHEET 4 OF 4
APPROVED	<del>JS</del>	TITLE	SCALE
DE APPR.	<del>JS</del>	PLATE	NTS
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